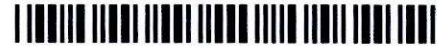




Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D2946-041
Job Sheet 211327



Part No: D2946-041

Job Qty: 1 pcs

Part Name: Step (AS350)



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 7/13/20

Job Tracking No:

Due Date: 7/17/20

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: D2946 REV.C IPP REV:A 18.04.20 NEW ISSUE DD VERF:JFS IPP REV.B 18/08/02 AS PER DWG REV:C
JFS VERF BY:DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Large Fab - Steps - 1	1 pcs	7/16/20		0.00	0.25	Large Fab - 1		DAS 24 9-89 <i>20-07-13</i>
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		
							Large Fab - 6		
							Large Fab - 7		
							Large Fab - 8		
							Large Fab - 9		
							Large Fab - 11 (Various)		
							Large Fab - 12		
120	QC 5	1 pcs	7/16/20		0.00	0.00	QC 5 - 10		DAS 43 9-89 <i>20-07-13</i>
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
							QC 5 - 61		



Container No: S287499



Part: D2946 - 041

Job No: 211327

Serial No/Batch: S287499

Revision: C

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
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CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 07/13/20

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FG102

130 Large Fab - Steps - 2 - B4B	1 pcs	7/16/20	0.00 1.25	QC 5 - 81	
				QC 5 - 82	III 13 2020
				Large Fab - 1 - B4B	
				Large Fab - 10 - B4B	
				Large Fab - 2 - B4B	
				Large Fab - 3 - B4B	DAS
				Large Fab - 4 - B4B	24 20-07-13
				Large Fab - 5 - B4B	9-89
				Large Fab - 6 - B4B	
				Large Fab - 7 - B4B	
				Large Fab - 8 - B4B	
				Large Fab - 9 - B4B	
				Large Fab - 11 - B4B (Various)	
				Large Fab - 12 - B4B	
135 QC 9	1 pcs	7/16/20	0.00 0.00	QC 9 - 10	
				QC 9 - 18	
				QC 9 - 24	
				QC 9 - 43	
				QC 9 - 50	20-07-15
				QC 9 - 9	
140 QC 5	1 pcs	7/16/20	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	20-07-15
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
145 Handfinish - 1-1 Chemical- B4B	1 pcs	7/16/20	0.00 0.17	QC 5 - 81	
				QC 5 - 82	
				Handfinish - 1 - 1 - B4B	
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	DAS
				Handfinish - 1 - 15 - B4B	24
				Handfinish - 1 - 16 - B4B	9-89
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	

				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
155 QC 7	1 pcs	7/16/20	0.00 0.00	QC 7 - 10	W 2020/07/15
				QC 7 - 13	
				QC 7 - 14	
				QC 7 - 15	
				QC 7 - 17	
				QC 7 - 18	
				QC 7 - 19	
				QC 7 - 2	
				QC 7 - 28	
				QC 7 - 3	
				QC 7 - 30	
				QC 7 - 34	
				QC 7 - 36	
				QC 7 - 37	
				QC 7 - 41	
				QC 7 - 47	
				QC 7 - 48	
				QC 7 - 51	
				QC 7 - 58	
				QC 7 - 59	
				QC 7 - 60	
				QC 7 - 9	
				QC 7 - 68	
				QC 7 - 50	
				QC 7 - 67	
				QC 7 - 40	DAS
				QC 7 - 24	24
				QC 7 - 43	9-89
				QC 7 - 61	
				QC 7 - 81	
				QC 7 - 76	
				QC 7 - 79	
				QC 7 - 83	
				QC 7 - 82	
				QC 7 - 87	
180 Large Fab - Steps - 3 - B4B	1 pcs	7/16/20	0.00 0.33	Large Fab - 1 - B4B	
				Large Fab - 10 - B4B	
				Large Fab - 2 - B4B	
				Large Fab - 3 - B4B	
				Large Fab - 4 - B4B	
				Large Fab - 5 - B4B	DAS
				Large Fab - 6 - B4B	24
				Large Fab - 7 - B4B	9-89
				Large Fab - 8 - B4B	
				Large Fab - 9 - B4B	
				Large Fab - 11 - B4B (Various)	
				Large Fab - 12 - B4B	
190 QC 9	1 pcs	7/16/20	0.00 0.00	QC 9 - 10	
				QC 9 - 18	
				QC 9 - 24	
				QC 9 - 43	DAS
				QC 9 - 50	43
				QC 9 - 9	9-89
200 QC 5	1	7/16/20	0.00 0.00	QC 5 - 10	

	pcs				QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	DAG
					QC 5 - 43	43
					QC 5 - 49	9-89
					QC 5 - 51	
					QC 5 - 58	20-07-20
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
					QC 5 - 61	
					QC 5 - 81	
					QC 5 - 82	
210 Handfinish - 1-2- Chemical-B4B	1 pcs	7/16/20	0.00 0.10		Handfinish - 1 - 1 - B4B	
					Handfinish - 1 - 2 - B4B	
					Handfinish - 1 - 3 - B4B	
					Handfinish - 1 - 4 - B4B	
					Handfinish - 1 - 5 - B4B	
					Handfinish - 1 - 6 - B4B	
					Handfinish - 1 - 7 - B4B	
					Handfinish - 1 - 8 - B4B	
					Handfinish - 1 - 9 - B4B	
					Handfinish - 1 - 10 - B4B	
					Handfinish - 1 - 11 - B4B	
					Handfinish - 1 - 12 - B4B	
					Handfinish - 1 - 13 - B4B	
					Handfinish - 1 - 14 - B4B	
					Handfinish - 1 - 15 - B4B	
					Handfinish - 1 - 16 - B4B	
					Handfinish - 1 - 17 - B4B	
					Handfinish - 1 - 18 - B4B	
					Handfinish - 1 - 19 - B4B	
					Handfinish - 1 - 20 - B4B	
					Handfinish - 1 - 21 - B4B	
					Handfinish - 1 - 22 - B4B	
220 Powdercoat - 1 White Gl(A)-B4B	1 pcs	7/16/20	0.00 0.25		Powdercoat - 1 - B4B	
					Powdercoat - 2 - B4B	
					Powdercoat - 3 - B4B	20-07-23
					Powdercoat - 4 - B4B	
					Powdercoat - 5 - B4B	
					Powdercoat - 6 - B4B	
					Powdercoat - 7 - B4B	
					Powdercoat - 8 - B4B	
					Powdercoat - 9 - B4B	
					Powdercoat - 10 - B4B	
230 Handfinish - 3-1- WingWalk-B4B	1 pcs	7/17/20	0.00 0.31		Handfinish - 3 - 1 - B4B	20-7-3
					Handfinish - 3 - 2 - B4B	
					Handfinish - 3 - 3 - B4B	
					Handfinish - 3 - 4 - B4B	
					Handfinish - 3 - 5 - B4B	
240 QC 3	1 pcs	7/17/20	0.00 0.00		QC 3 - 10	
					QC 3 - 13	
					QC 3 - 15	
					Plex 7/13/20 7:33 AM Dart.lajeunesse.marie	

				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	
				QC 3 - 68	
				QC 3 - 9	
				QC 3 - 40	
				QC 3 - 19	
				QC 3 - 43	
				QC 3 - 24	DAS
				QC 3 - 61	81
				QC 3 - 81	9-89
				QC 3 - 82	
				QC 3 - 87	
270	Packaging 3-1 - Stock - B4B	1	7/17/20	0.00 0.00	Packaging 3 - 1 - B4B
	pcs				Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B
					Packaging 3 - 16 - B4B
					Packaging 3 - 17 - B4B
					Packaging 3 - 18 - B4B
					Packaging 3 - 19 - B4B
					Packaging 3 - 20 - B4B
					Packaging 3 - 21 - B4B
					Packaging 3 - 22 - B4B
					Packaging 3 - 23 - B4B
					Packaging 3 - 24 - B4B
					Packaging 3 - 25 - B4B
					Packaging 3 - 26 - B4B
					Packaging 3 - 27 - B4B
					Packaging 3 - 28 - B4B
					Packaging 3 - 29 - B4B
					Packaging 3 - 30 - B4B
					Packaging 3 - 31 - B4B
					Packaging 3 - 32 - B4B
					Packaging 3 - 33 - B4B
					Packaging 3 - 34 - B4B
					Packaging 3 - 35 - B4B
					Packaging 3 - 36 - B4B
					Packaging 3 - 37 - B4B

JUL 31 2020

DAS
72
9-89 AUG 06 2020

280 QC 21 - FG

1
pcs

7/17/20

0.00 0.00

QC 21 - FG - 21

21

AUG 06 2020

QC 21 - FG - 70

9-09

QC 21 - FG - 9

QC 21 - FG - 77

Part Op 110 - (Fabricate per Drwg)1-Cut D2622-120 extrusion to 62.06" long as per Dwg D2946 2- Drill hole and C'sink as per Descriptions: dwg. 3-Deburr **Ensure that 57.09" minimum extrusion is kept and identify to be used for D350-591-215/-216.**

120 - (QC5- Inspect part completeness to step on W/O)

130 - (Weld per dwg A/R Aluminum rod Batch: 139019 1-Deburr and Bevel ends for welding 2-Weld (1) End Cap and (2) Lugs using Jig DT8440 as per Dwg D2946 A/R Aluminum Rod 139019 3-Grind End Cap welds flush

135 - (QC9- Inspect visual per QSI004- Fusion Welds)

140 - (QC5- Inspect part completeness to step on W/O)

145 - (Chemical Conversion Coat per QSI005 4.1)

155 - (QC7-Inspect Chemical Conversion Coat)

180 - (Weld per dwg A/R Aluminum rod Batch: 139019 1- Remove alodine prior to welding. Weld end cap as per Dwg D2946. Grind end cap weld flush. A/R AL ROD BATCH: 139019 2- Plug hole with rivet after welding as per Dwg (Note10)

190 - (QC9- Inspect visual per QSI004- Fusion)

200 - (QC5- Inspect part completeness to step on W/O)

210 - (Chemical Conversion Coat per QSI005 4.1)

220 - (White Gloss (Ref: 4.3.5.1) per QSI005 4.3-Alum) START TIME: 10:40 OVEN TEMPERATURE: 320
FINISH TIME: 11:10

230 - (Wing Walk as per dwg QSI005 4.4 Batch _____)

240 - (QC3- Inspect Part Finish)

270 - (Identify as per dwg & Stock Location: _____)

280 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2622-120C	Step Extrusion	1 pcs (1 ea)	110-Large Fab - Steps - 1	5 243427
D2734	Step End Plate	2 pcs (2 ea)	130-Large Fab - Steps - 2 - B4B	5259367
D2944	Step Mounting Plate	2 pcs (2 ea)	130-Large Fab - Steps - 2 - B4B	5273841
MS20601-AD4W2	Rivet	1 Ea (1 ea)	180-Large Fab - Steps - 3 - B4B	5252767

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Large Fab - Steps - 1	D2622-120C	1	259	0
130-Large Fab - Steps - 2 - B4B	D2734	2	95	0
	D2944	2	51	0
180-Large Fab - Steps - 3 - B4B	MS20601-AD4W2	1	372	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Step Mounting Plate	0.257Inches + 0.006 - 0.001	0.263 0.256		Diameter
2	Step Mounting Plate	0.559Inches ± 0.010	0.569 0.549		
3	Step Mounting Plate	3.040Inches ± 0.030	3.070 3.010		
4	Step Mounting Plate	1.950Inches ± 0.030	1.980 1.920		
5	Step Mounting Plate	0.852Inches ± 0.010	0.862 0.842		
6	Step Mounting Plate	2.715Inches ± 0.001	2.716 2.714		
7	Step Mounting Plate	3.400Inches ± 0.030	3.430 3.370		

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					